

Work Order ID 54918

Page 1

January 7, 2010 10:51:01 AM

Item ID: D206-642-241

Reference:

Revision ID:

Item Name: Replacement Skidtube

Start Date: 1/07/10

Start Qty: 1.00

Cust Item ID:

Required Date: 1/18/10

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
-------------	----------------	-----------------------	--------	-----	-------------	-----------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr.

D2650

Rev F

100

DC

Document Control

0.00

0.00

Memo

DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-241 CHG005

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54918

January 7, 2010 10:51:06 AM

Page 3

Item ID: D206-642-241

Reference:

Revision ID:

Item Name: Replacement Skidtube

Start Date: 1/07/10

Start Qty: 1.00

Cust Item ID:

Required Date: 1/18/10

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
		10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.									
		11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.									
		12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650									
		13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder									
		14-Remove indexing edge using DT8741 as per Dwg D2650									
		15-C'sink GHW rivet holes as per Dwg D2650									

120

QC

QC6- Inspect dimensions to drawing

0.00

0.00

→ 8 10/11/20

Quality Control

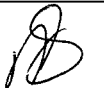

Memo

(H)

Pto →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-241 PAR #: _____ Fault Category: Skid holes NCR: (Yes) No DQA: 2 Date: 10-02-10
 Resolution: re-work Disposition: re-work QA: N/C Closed: HJ Date: 10/02/11

NCR: 54918		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/17	# 110. 10	13 holes are ovalized/elongated for Rivets to not doublets. R.C "Pross" drilled through	 GEPH	→ Fill all 13 marker hls. with weld. A/R <u>m112507</u> Per ASTM → Grind welds Flush in side part	BE 10/01/20 H 10/11/20	S 10/01/20	 29042	S 10/01/20
		Al. to SS cause lots of problems		→ redrill and c'sink per Aug	H 10/11/20	S 10/01/20		S 10/01/20

NOTE: Date & initial all entries

January 7, 2010 10:51:06 AM

Reference:

Item Name: Replacement Skidtube

Start Qty: 1.00

Cust Item ID:

Req'd Qty: 1.00

Customer ID:

Customer Name:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54918

January 7, 2010 10:51:07 AM

Page 5

Item ID: D206-642-241

Reference:

Revision ID:

Item Name: Replacement Skidtube

Start Date: 1/07/10

Start Qty: 1.00

Cust Item ID:

Required Date: 1/18/10

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	Skidtubes	0.00	0.00							
		Memo									
		1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)									
		2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)									
		3-Deburr and blow out all chips from inside the tube									
170	QC	QC6- Inspect dimensions to drawing	0.00	0.00							
	Quality Control										
		Memo									

410/1/21

⇒ 810/01/21

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

January 7, 2010 10:51:12 AM

Reference:

Item Name: Replacement Skidtube

Cust Item ID:

Customer ID:

Customer Name:

Date:

Date:

Hours

0.00

1-Locate, install and rivet doublers as per Dwg D2650.
Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 12/1/27 Time: 12:30
Finish Date: 12/1/27 Time: 3:15 pm

Qty	Part Number	Description	Batch

A/R [1] Sikaflex-291 [1] M112395 [1]

Sikaflex expire date: ☐ 6/3/30

0.00

0.00

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54918

January 7, 2010 10:51:12 AM

Page 7

Item ID: D206-642-241

Reference:

Revision ID:

Item Name: Replacement Skidtube

Start Date: 1/07/10

Start Qty: 1.00

Cust Item ID:

Required Date: 1/18/10

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Skidtubes	Skidtubes	0.00	0.00							
		Memo									
		1-remove alodine from around hole and prepare for welding									
		2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. Pick: Qty Part Number Description Batch A/R Aluminum Rod 1 <u>M112507</u>									
		3-Grind welds flush as per Dwg D2650.									
		4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. A/R SS Rod: <u>NONE</u>									
		5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr									
210	HandFinish	HandFinishing	0.00	0.00							
	Hand Finishing	Memo									
		Install D2680-041 Nut Plate as per Dwg D2650									

BE 10/1/25

BE 10/1/25

BE 10/1/25

H 10/1/25

H 10/1/25

January 7, 2010 10:51:18 AM

Reference:

Revision ID:

Item Name: Replacement Skidtube

Start Date: 1/07/10**Start Qty:** 1.00**Cust Item ID:**

Required Date: 1/18/10

Req'd Qty: 1.00**Customer ID:**

Customer Name:

Approvals:

Process Plan:

Date:**Tooling:**

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00	0.00							
	Memo				QCA → PD 10.01.26						
					QC10 → S1010126						
230	QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00	0.00							
	Memo				⇒ S1010126			(X)	✓		
240	HandFinish Hand Finishing	Pressure Wash per QSI005 4.3	0.00	0.00							
	Memo				BR 10-a-26						
250	Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00	0.00							
	Memo	START TIME: 1:00pm OVEN TEMPERATURE: 320° FINISH TIME: 1:30pm			⇒	Sel 10-01-26		(X)	✓		
260	QC Quality Control	QC3- Inspect Part Finish	0.00	0.00							
	Memo				M-L 10/01/28			(IX)			

Work Order ID 54918

January 7, 2010 10:51:18 AM

Page 9

Item ID: D206-642-241

Reference:

Revision ID:

Item Name: Replacement Skidtube

Start Date: 1/07/10

Start Qty: 1.00

Cust Item ID:

Required Date: 1/18/10

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	HandFinish	HandFinishing	0.00	0.00							
	Hand Finishing	<p>Memo</p> <p>1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R <input type="checkbox"/> Sikaflex-2911 <u>M11234S</u> Sikaflex expire date: <u>10/08</u></p> <p>2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.</p> <p>3-Install MS27039-4-06 Screw as per DEO 9153.</p> <p>4 -Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R <input type="checkbox"/> Sikaflex-2911 <u>M11234S</u> Sikaflex expire date: <u>10/08</u></p> <p>5 -Wing Walk as per Dwg D2650-3 and QSI 005 4.4 A/R Batch: <u>M11354S</u> Batch: <u>M11354S</u></p>									
300	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00							
	Quality Control	<p>Memo</p>									

M-k 10/01/28

IX

⇒ S 10/01/29

40

Work Order ID 54918

January 7, 2010 10:51:23 AM

Page 10

Item ID: D206-642-241

Reference:

Revision ID:

Item Name: Replacement Skidtube

Start Date: 1/07/10

Start Qty: 1.00

Cust Item ID:

Required Date: 1/18/10

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310	Packaging	Packaging	0.00	0.00				10-2-3		sf	
	Packaging	Memo									
		Identify and pack for shipping as per PPP D206-664-241									
		Location: _____									
		PPP Rev: _____									
		PPP 54905									
320	QC	QC21- Final Inspection - Work Order Release	0.00	0.00							
	Quality Control	Memo									

10/02/04 LJ
MF 10-2-3

Picklist Print

January 7, 2010 10:50:38 AM

Page 1

Work Order ID: 54918

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 1/07/10

Required Date: 1/18/10

Comments: IPP Rev: 04.12.02 Revised procedural steps iKJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3286-1		Manufactured	No			110	Each	45.0000	2.0000			



Doubler

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 45

47692 15

52844 30

D2647

Manufactured No

110

Each

7.0000

1.0000



Cap

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 7

10773 7

12620

10/01/07

B2600-T-160

Manufactured No

110

Each

57.0000

1.0000



Extrusion Round 3" 206

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 57

43969 57

A

2 54448

(x1)

BE

10/01/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 10:50:39 AM

Work Order ID: 54918



Parent Item: D206-642-241



Parent Item Name: Replacement Skidtube

Start Date: 1/07/10

Required Date: 1/18/10

Comments: IPP Rev: 04.12.02 Revised procedural steps [KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:ECU]

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2654-3		Manufactured	No			180	Each	6.0000	1.0000			



Web



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

48679

6

CR3212-4-04

Purchased

No

180

Each

286.0000

52.0000



Cherry Rivet



1/10/1/21

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

286

109297

26

109740

16

110153

6

111127

78

112314

20

112612

140

62

1/10/1/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 10:50:39 AM

Page 3

Work Order ID: 54918



Parent Item: D206-642-241



Parent Item Name: Replacement Skidtube

Start Date: 1/07/10

Required Date: 1/18/10

Comments: IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649		Manufactured	No			200	Each	202.0000	18.0000			



Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

83

51529

83

Main Warehouse

ST

119

36013

5

47112

110

48271

4

D3286-3

Manufactured No

200

Each

31.0000

2.0000



Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

31

35048

1

41900

1

46643

29

18 8E 10/01/25

2 8E 10/01/25

January 7, 2010 10:50:39 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 10:50:40 AM

Page 4

Work Order ID: 54918



Parent Item: D206-642-241



Parent Item Name: Replacement Skidtube

Start Date: 1/07/10

Required Date: 1/18/10

Comments: IPP Rev: 04.12.02 Revised procedural steps [KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC]

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2680-041		Manufactured	No			210	Each	65.0000	1.0000			



Nut Plate



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

65

33061

1

44086

64

CR3212-4-03

Purchased

No

210

Each

274.0000

2.0000



Cherry Rivet



BSS366

① 1/10/1/25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

274

111359

84

112314

190

2 1/10/1/25

January 7, 2010 10:50:40 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 10:50:40 AM

Page 5

Work Order ID: 54918



Parent Item: D206-642-241



Parent Item Name: Replacement Skidtube

Start Date: 1/07/10

Required Date: 1/18/10

Comments: IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CCR264SS3-3		Purchased	No			210	Each	333.0000	2.0000			



Cherry Rivet



Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	333	
111548	20	
111827	1	
112314	20	
113064	92	
113539	200	

D2646

Manufactured No

270

Each

63.0000

1.0000



Aft Cap



Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

FP6	29	
52663	29	
Main Warehouse		
fp7	13	
52663	13	

Main Warehouse

ST	21	
46323	4	
48109	17	

46323
48109 ✓

2

W 10/11/25

IX M-L 10/01/28

January 7, 2010 10:50:40 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 10:50:41 AM

Work Order ID: 54918



Parent Item: D206-642-241



Parent Item Name: Replacement Skidtube

Start Date: 1/07/10

Required Date: 1/18/10

Comments: IPP Rev: 04.12.02 Revised procedural steps [KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC]

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-1		Manufactured	No			270	Each	594.0000	18.0000			



Plug

Warehouse Loc Qty Loc Code

Location

Main Warehouse

fpa

295

53349

295

Main Warehouse

ST

299

43990

57

51530

242

AN960JD416

Purchased

No

270

Each

1,489.000

1.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1489

103691

20

104215

6

108161

329

110523

340

111279

101

111916

482

112314

211

16941

0

NAS1149D0463J

113288

1x m-l 10/01/28

3x m-l 10/01/28
15x m-l 10/01/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 10:50:41 AM

Work Order ID: 54918



Parent Item: D206-642-241



Parent Item Name: Replacement Skidtube

Start Date: 1/07/10

Required Date: 1/18/10

Comments: IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:ECU

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2651-3

Manufactured

No

270

Each

783.0000

18.0000



O-Ring

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

783

3

780

43849

46114

MS27039-1-08

Purchased

No

270

Each

2,792.000

46.0000



Screw

~~18X~~ m-l 10/01/28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2792

112

680

2000

110467

110552

110835

ALS4-1032-130

Purchased

No

270

Each

2,651.000

44.0000



Insert

~~46X~~ m-l 10/01/28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2651

2651

110511

~~44X~~ m-l 10/01/28

January 7, 2010 10:50:42 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 10:50:43 AM

Page 8

Work Order ID: 54918

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 1/07/10

Required Date: 1/18/10

Comments: IPP Rev: 04.12.02 [Revised procedural steps: KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC]

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-4-06		Purchased	No			270	Each	57.0000	1.0000			



Screw

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST

57

109061

57

AN960JD10L

Purchased

No

270

Each

4,821.000 46.0000



Washer

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST

4821

101291

16

104885

16

105793

185

109632

170

110985

4434

ix m-p 10/01/28

46x m-p 10/01/28

January 7, 2010 10:50:43 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 10:50:49 AM

Page 9

Work Order ID: 54918

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Comments: IPP Rev: 04.12.02 [] Revised procedural steps [] KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC []

Start Date: 1/07/10

Required Date: 1/18/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1		Manufactured	No			270	Each	141.0000	4.0000			



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

2

48288

2

Main Warehouse

FP17

139

51678

34

51679

105

D3537-3

Manufactured

No

270

Each

40.0000

1.0000



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

40

33881

6

35697

34

42 m/d 10/01/28

1X m/d 10/01/28

January 7, 2010 10:50:49 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 10:50:50 AM

Page 10

Work Order ID: 54918

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Comments: IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC

Start Date: 1/07/10

Required Date: 1/18/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

37584

38759

21

7

14

270

Each

17.0000

1.0000

D3536-13



Gasket

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

38761

17

17

270

Each

9.0000

1.0000

D3535-21



Wearshoe

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

37624

9

9

IX m-l 10/01/28

IX m-l 10/01/28

IX m-l 10/01/28

January 7, 2010 10:50:50 AM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 10:50:55 AM

Page 11

Work Order ID: 54918

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Comments: IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC

Start Date: 1/07/10

Required Date: 1/18/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-21		Manufactured	No			270	Each	14.0000	1.0000			



Gasket

Warehouse
Location

Main Warehouse

ST

Loc Qty

14

Loc Code

37351

2

47010

12

D3535-33

Manufactured No

270

Each

13.0000

1.0000



Wearshoe

Warehouse
Location

Main Warehouse

FP

Loc Qty

13

Loc Code

51647

13

D3536-33

Manufactured No

270

Each

12.0000

1.0000



Gasket

Warehouse
Location

Main Warehouse

ST

Loc Qty

12

Loc Code

51593

12

January 7, 2010 10:50:55 AM

Shop Packet Print

Page 11

IX m.k 10/01/28

IX m.k 10/01/28

IX m.k 10/01/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2690-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54918

10-1-05

RELEASED
08-07-23

F

NOTES:

MATERIAL: N/A

FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER

DART QSI 005 4.4

TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.010 MAX

IDENTIFICATION: NONE

WEIGHT: N/A

WELD PER DART QSI 004

DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-2411-291 ADHESIVE PER DART QSI 015

) INSERT D2651-1 PLUG CW/ D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.

) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	03.08.06
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.20
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, MA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		208/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED, OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

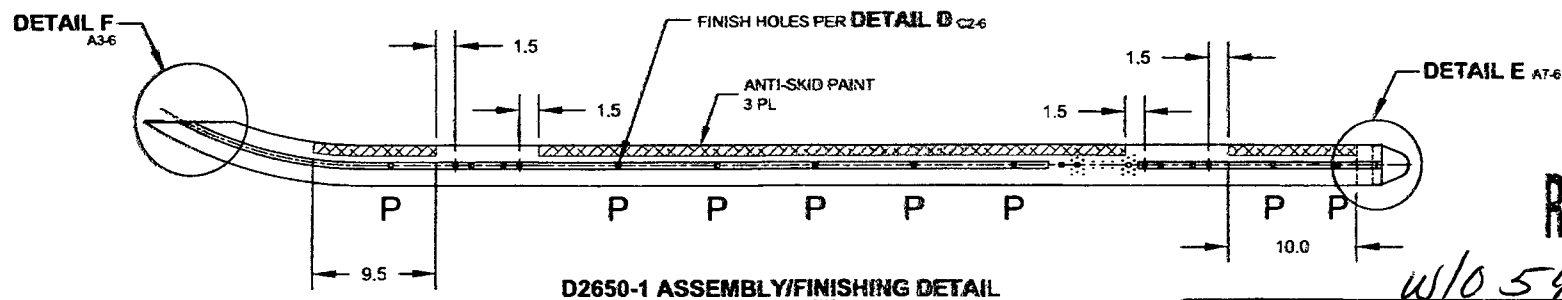
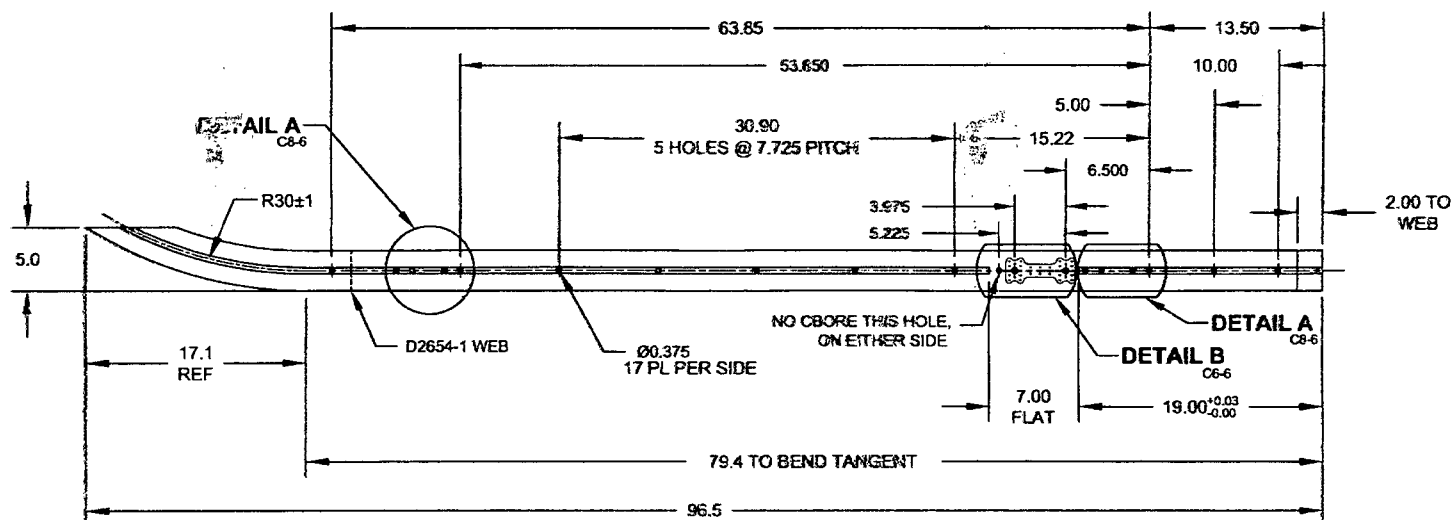
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, MA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASED
8/12/18

W10 54917

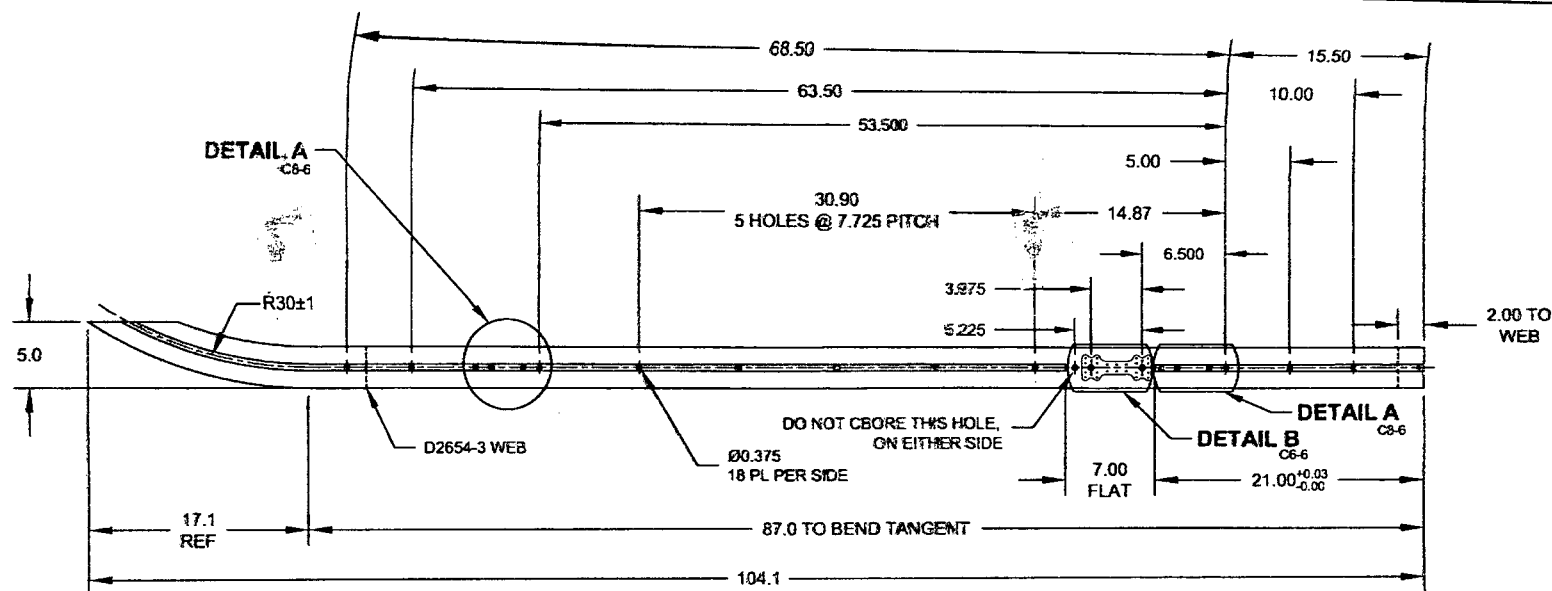
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

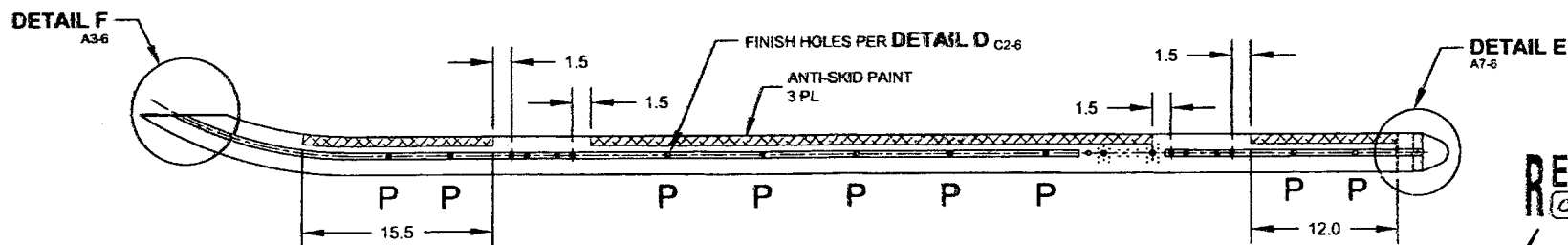
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

RELEASED
05 07 82

W/O 54918

DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, MA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

Dart Aerospace Ltd

WORK ORDER CHANGES							
W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

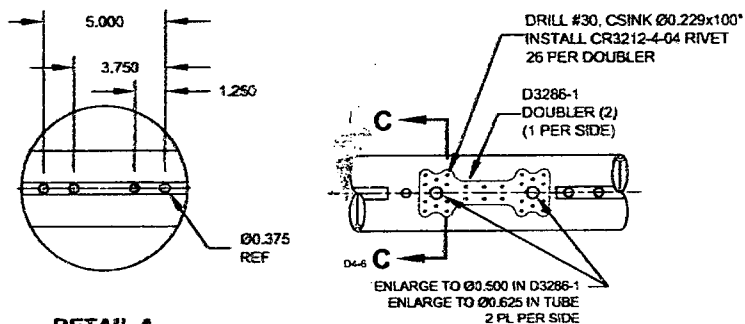
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

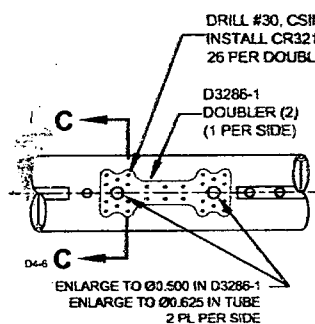
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

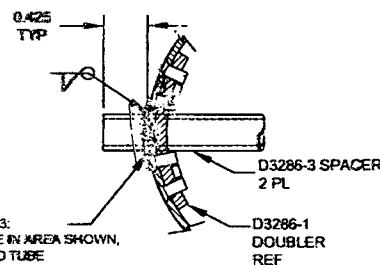


DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

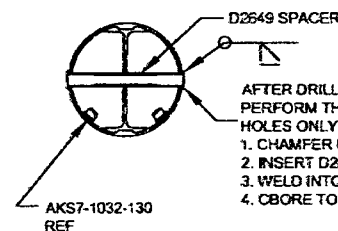


DETAIL B
SCALE 2X
C3-2
C3-3

SECTION C-C C7-6
SCALE NONE

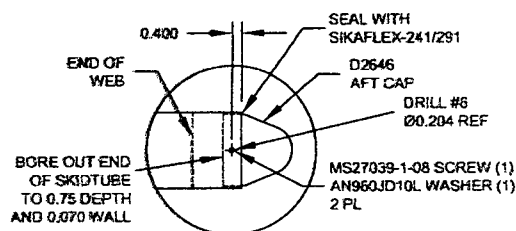


- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.

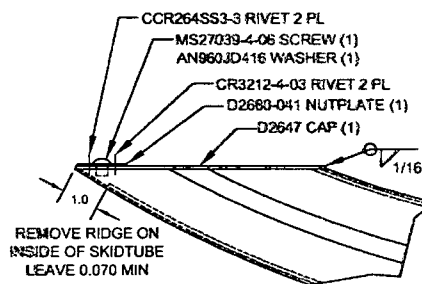
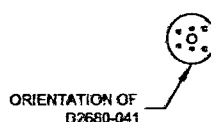


DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5

- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP






DETAIL E
SCALE 2X
B6-2
B6-3
B1-4
B1-5



DETAIL F
SCALE NONE
B6-2
B6-3
B6-4
B6-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR
TO FINISH

RELEASED
05 09 22 19

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

W/10 54918

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 216

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: D206 52867
Part number: D206 642.541
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P. J. D. S. L. Date of Test Coupon 09-11-10
Welder Barclay Elliott Date of Test Coupon 09-11-10

The above named individual is qualified in accordance with AWS D17.1.2001 to weld